

Reprint

Work Order ID 135003

135003

Page 1

July-28-15 9:00:03 AM

Item ID: D4038-9

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Block

Start Date: 23/07/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 07/08/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4038	E								
100		0.00							DAS 40 9-89
100						2	0		15/07/28
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	CUT BLANK 1.750" LONG								
105		0.00							DAS 40 9-89
105						2	0		15/07/28
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Mill as per Dwg and Folio FA885 DWG REV: <u>E</u> FOLIO REV: <u>AA</u> DEBURR								

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Page 2

Item ID: D4038-9

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Block

Start Date: 23/07/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 07/08/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

2ØDAS
40
9-89

15/07/28

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

2ØDAS
08
9-89

15/07/29

130

Chemical Conversion Coat per QSI005 4.1

0.00

130

HandFinish

Memo

0.00

Hand Finishing

2Ø

15-7-30 JL

Picklist Print

July-28-15 9:00:02 AM

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Work Order ID: 135003

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Parent Item: D4038-9

D4038-9

Parent Item Name: Block

Start Date: 23/07/2015

Required Date: 07/08/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: Ipp Rev:A New Issue 09-12-14 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.00 0		Purchased	No				f	11.8437		0.349474			DAS 40 9-89
M6061T6B1 500X02 000									**		15/07/28		
6061-T6 Bar 1.50 x 2.00													

Location

Loc Qty

Loc Code

MAT

10.9

m131700

10.9

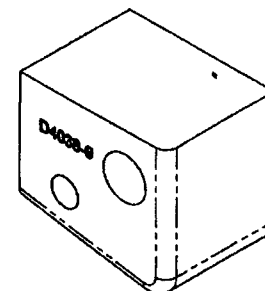
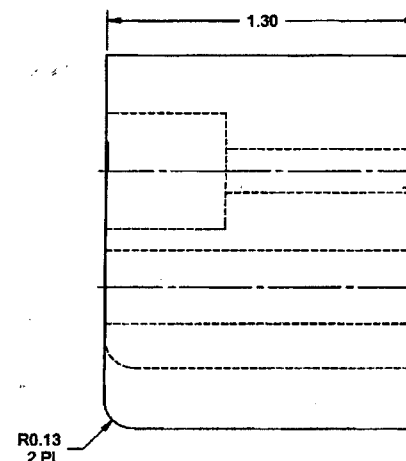
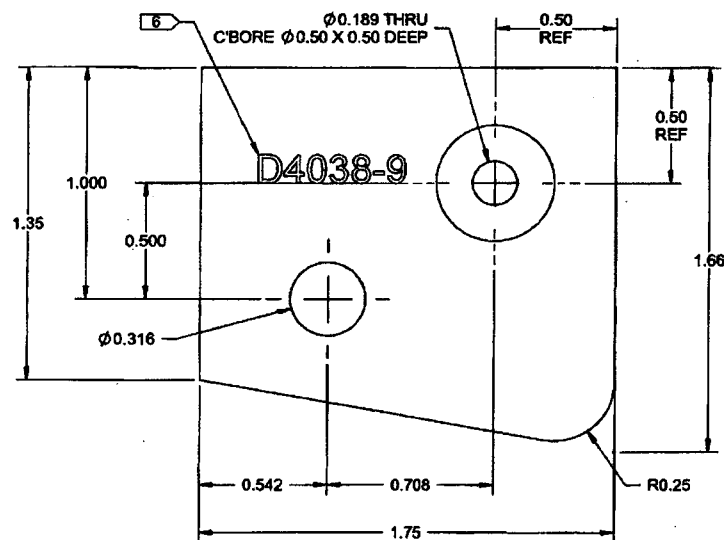
MAT004

0.9437

→ m126726

0.9437

• 3437



D4038-9 BLOCK

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N IN THIS AREA AS SHOWN TO MAX DEPTH
OF 0.010 IN 0.12 HIGH LETTERS WITH MIN RADIUS TOOL OF 0.015
- 7) WEIGHT: 0.31 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D4038	SHEET 11 OF 14
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
DATE	11.04.11	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PROPRIETARY AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR DISCLOSED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASED
R 2011-04-21

DART AEROSPACE LTD		Work Order: 135003
Description: Block		Part Number: D4038-9
Inspection Dwg: D4038 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.35	$\pm .030$	1.350	✓		VERU	PH6-12
1.000	$\pm .010$	1.000	✓			
.500	$\pm .010$	.500	✓			
Ø .316	$\pm .006$ $\pm .001$	.319	✓			
.542	$\pm .010$	.541	✓			
.708	$\pm .010$	.708	✓			
1.75	$\pm .030$	1.750	✓			
R.25	$\pm .030$	.250	✓			
Ø .189	$\pm .005$ $\pm .001$	.191	✓			
CB Ø .500	$\pm .030$	.501	✓			
CB F .500	$\pm .030$	.500	✓			
1.30	$\pm .030$	1.303	✓			
R.13	$\pm .030$	.125	✓			

Measured by: DAS 40 9-89		Audited by: <i>[Signature]</i> Date: 15/07/29		DAS Preliminary Approval: 08 Date:	
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Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

[Signature] 10.04.15